

S247365



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2423

Job Sheet 202743

L.C.
208A

S247365 UM

Part No: D2423

Job Qty: 280 ft

Part Name: Lug Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 12/20/19

Description:

Type: Stock

Note: DWG REV B1 IPP G 04.09.02 Part Number D2423-108 changed to D2423 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	280 ft	12/20/19	12/20/19	0.00	0.00	Purchasing - 1		DEC 23 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	280 pcs	12/20/19	12/20/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		JAN 14 2020
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		DEC 23 2019
							Packaging 2 - 10 - B4B		JAN 14 2020
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S247365



Part: D2423

Job No: 202743

Serial No/Batch: S247365

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/14/20

Plex 11/1/19 11:22 AM Dart.Guerin.Kimberley

						B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
120	QC 6	280 pcs	12/20/19	0.00	0.00	QC 6 - 9	
						QC 6 - 68	JAN 14 2020
						QC 6 - 61	
						QC 6 - 40	
						QC 6 - 81	DEC 7 3 2019
130	Packaging 3-1 - Stock - B4B	280 pcs	12/20/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	

Plex 11/1/19 11:22 AM Dart.Guerin.Kimberley

					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS 31 JAN 14 2020
					Packaging 3 - 36 - B4B	DAS 21 31 JAN 07 2020
140 QC 21 - SA FT	280 ft	12/20/19	0.00 0.00		QC 21 - SA - 21	DAS 21 31 JAN 07 2020
					QC 21 - SA - 70	DAS 21 31 JAN 07 2020
					QC 21 - SA - 53	DAS 21 31 JAN 14 2020

Part Op 100 - (Purchasing) Issue P/O: _____ Manufacture as per Dwg Possible Supplier: SIGNATURE

Descriptions: ALUMINUM

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2423P	Lug Extrusion	280 ft (1 ea)	100-Purchasing - Ft	5243432

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D2423P	280	0	0

Part Specifications	
Specifications could not be found.	

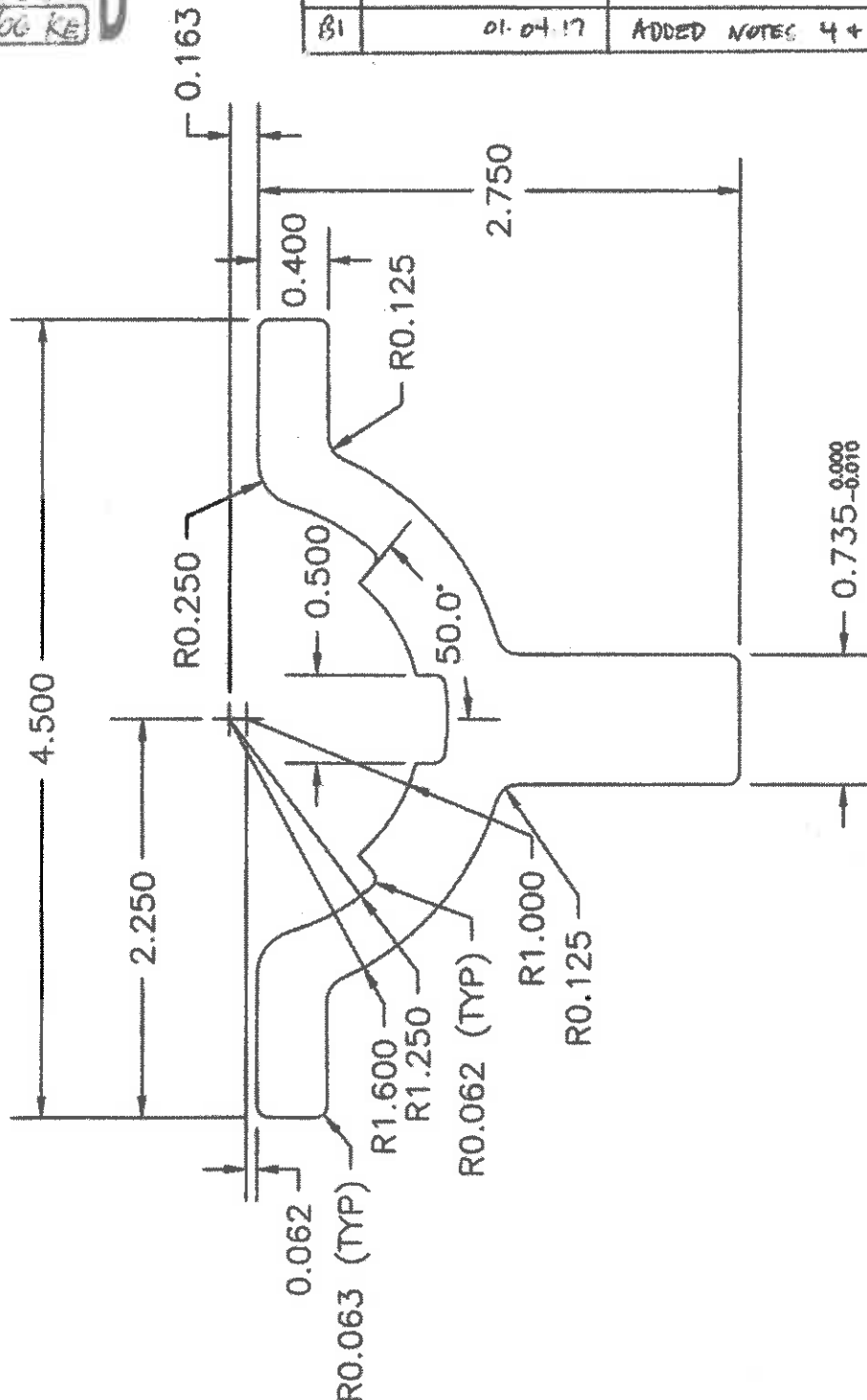
Plex 11/1/19 11:22 AM Dart.Guerin.Kimberley

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4+5 <i>4 CP</i>	

RELEASED
99/09/06 KE



UW

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)

2. NOTE: ALL DIMENSIONS ARE IN INCHES

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4. MANUFACTURED USING CARBIDE INDEX DIE # M3-12806

5. PART NUMBER IS D2423-XXX WHERE XXX IS PART LENGTH IN INCHES (E.G. D2423-108 IS 108" LONG)

*Line 2
D2423*



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044949



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB044949

PO Date: 10/30/19

Due Date: 12/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202547	D2622-120CP	D2962 Rev C		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	-	12/20/19	163 pcs	0 pcs	163 pcs	\$25,2487/pcs	\$4,115.54
2	202743	D2423P	D2423 Rev B1		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	-	12/20/19	280 ft	0 ft	280 ft	\$10.3178/ft	\$2,888.98
Grand Total:												\$7,004.52	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044949



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 12/23/19 2:41 PM dart.lussier.patrick

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
12/16/2019	5561427	138199	1
Cust PO	B/L No.	Lot	Date
POHB044949	046141	929200	12/17/19

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
002	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	787 LBS		
Net Qty	774 LBS 26 PCS 1 PKGS		
Specification	AMS QQA 200/8 + ASTM B221		Die Desc

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
324.2 / 47.0	295.9 / 42.9	12.4	N/A	95

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.66	0.30	0.24	0.05	0.88	0.08	0.15	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

LINE 2

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423DATE: DEC 23 2019PO / BATCH NO.: POH120449495243432MATERIAL CERT REC'D: YESQUANTITY RECEIVED: 208 ftQUANTITY INSPECTED: 208 ftQUANTITY REJECTED: —THICKNESS ORDERED: —THICKNESS RECEIVED: —SHEET SIZE ORDERED: —SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>QQ -A -20018</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>HKT 929200</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.
RECORD RESULTS BELOW

	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION

ENGINEERING SIGNOFF (if required)

INSPECTED BY: 82
9-89

SIGNED OFF BY: _____

DATE: DEC 23 2019

DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

2



SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No.	Sales Order	Page
12/16/2019	5561427	138199	1
Cust PO	B/L No.	Lot	Date
POHB044949	046141	929200	12/17/19

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
002	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	787 LBS		
Net Qty	774 LBS	26 PCS	1 PKGS
Specification		Mat Desc	
AMS QQA 200/8 - ASTM B221		DAS 12 JAN 07 2020	

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
324.2 / 47.0	295.9 / 42.9	12.4	N/A	95

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.66	0.30	0.24	0.05	0.88	0.08	0.15	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

LIVE 2
D2423P

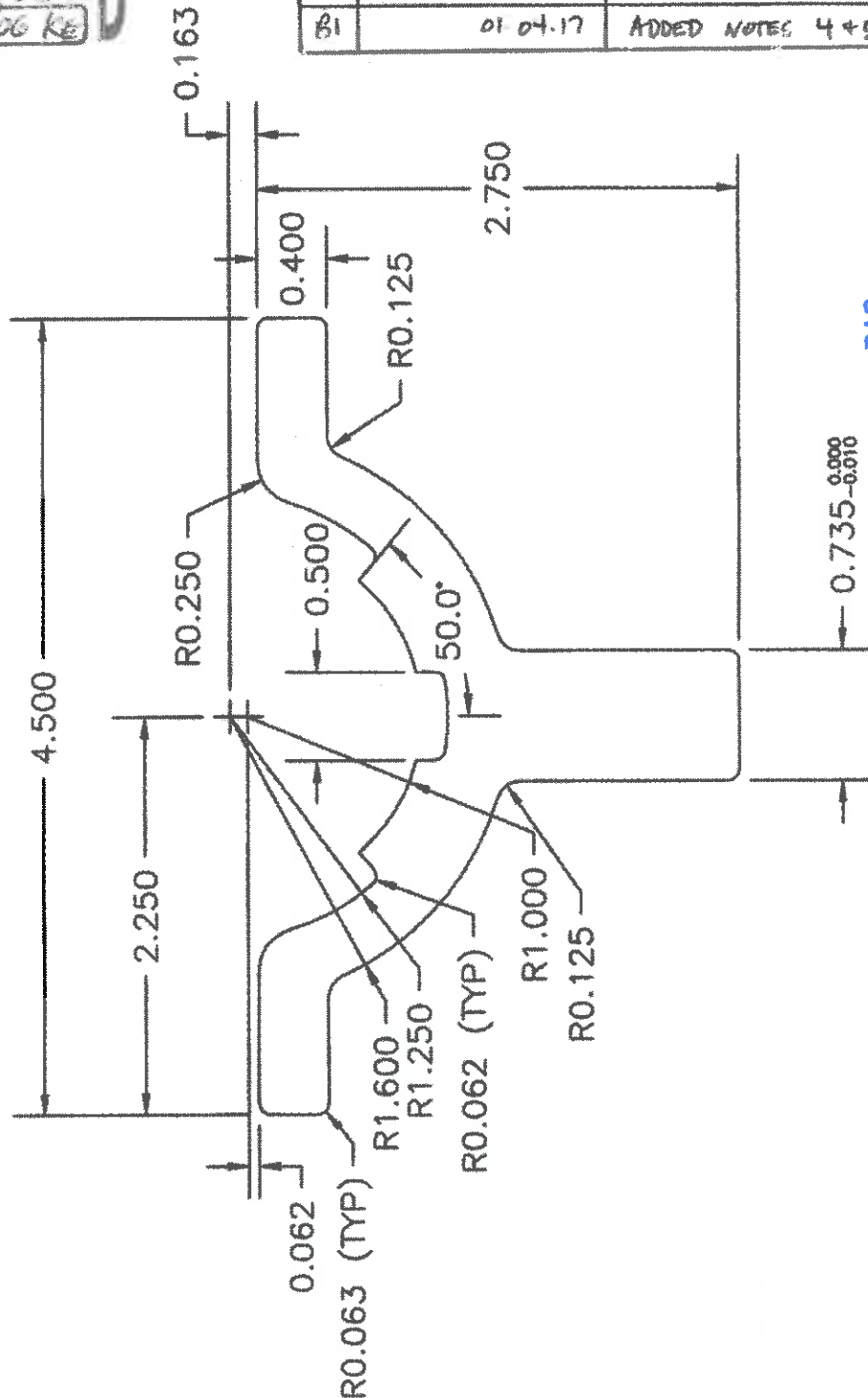
POH8044949
H/T 929200

2



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04	TITLE LUG EXTRUSION		SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01-04-17	ADDED NOTES 4+5 <i>IP</i>	

RELEASED
94/04/06 *KE*



DAS
82
9-89

IAN 17 7020

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)

2. NOTE: ALL DIMENSIONS ARE IN INCHES

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4. MANUFACTURED USING CAMBION INJECTION DIE # MS-12866

5. PART NUMBER IS D2423-V01 WHERE N/A IS CMT LENGTH IN INCHES (E.G. D2423-108 IS 108" LONG)

LINE 2
D2423P

(2)

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423P
DATE: JAN 07 2020

PO / BATCH NO.: POHB044949
5243432

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 208ft
QUANTITY INSPECTED: 208ft
QUANTITY REJECTED: —

THICKNESS ORDERED: —
THICKNESS RECEIVED: —
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS QQ-A-200
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HIT 929200
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.
RECORD RESULTS BELOW

	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>82</u> <u>9-89</u>	SIGNED OFF BY: _____
DATE: <u>JAN 07 2020</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in